

ABSTRACT OF THE DISCLOSURE

A polymer extrusion head for forming continuous shapes having one or more
5 lumens therein. The head includes an extrusion mandrel and die. At least one lumen
pipe is disposed radially through a port in the die to intersect the polymer flow in the
annular region between the tip and the die. The lumen pipe is a welded assembly
having a 90° turn formed as a mitered joint with zero bend radius. The lumen pipe is
held in a pin vise engaged in the die such that position of the lumen pipe may be readily
10 adjusted. Axial and radial positions are established during assembly by means of a
gauge block. A plurality of lumen pipes may be accommodated for a plurality of lumens
by a manifold distribution system including individual lumen pipe assemblies.